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D3414-041
Job Sheet 206350



Part No: D3414-041

Job Qty: 12 pcs

Part Name: Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/20

Job Tracking No:

Due Date: 2/21/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Large Fab - Welded Assy-1	12 pcs	2/21/20		0.00	2.40	Large Fab - 1		MV Feb 28/20
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
150	QC 9	12 pcs	2/21/20		0.00	0.00	QC 9 - 10		G
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
160	QC 5	12 pcs	2/21/20		0.00	12.00	QC 5 - 10		*
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S259193



Part No: D3414-041

Job No: 206350

Material No/Batch: S259193

Revision:
Manufacturer:

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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	62
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170	Powdercoat - 2 White GI(S)- B4B	12 pcs	2/21/20	0.00 0.25	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
180	QC 3	12 pcs	2/21/20	0.00 12.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
190	Packaging 3-1 - Stock - B4B	12 pcs	2/21/20	0.00 12.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

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				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
200	QC 21 - SA	12 pcs	2/21/20	0.00 12.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op 140 - (Weld per dwg A/R S.S. rod Batch: M138974) 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S.
 Descriptions: welding rod Batch: _____

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3414-3	Lug	12 pcs (1 ea)	140-Large Fab - Welded Assy-1	* 5230378 / 5242825 5238662
D3414-1	Lug Bracket	12 pcs (1 ea)	140-Large Fab - Welded Assy-1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Welded Assy-1	D3414-1	12	39	0
	D3414-3	12	44	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lug Bracket	0.313inches + 0.006 - 0.001	0.319 0.312		
2	Lug Bracket	1.190inches ± 0.030	1.220 1.160		
3	Lug Bracket	1.000inches ± 0.030	1.030 0.970		
4	Lug Bracket	3.380inches ± 0.030	3.410 3.350		
5	Lug Bracket	5.350inches ± 0.010	5.360 5.340		
6	Lug Bracket	6.230inches ± 0.030	6.260 6.200		
7	Lug Bracket	2.500inches ± 0.010	2.510 2.490		
8	Lug Bracket	0.370inches ± 0.030	0.400 0.340		
9	Lug Bracket	0.100inches ± 0.010	0.110 0.090		

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		QTY Affected :		MRB (QS1042)	
Date :		Sequence #:		Cross tube Small Fab Finishing		Skid-tube Machining Large Fab		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
Description Work Order Deviation		Disposition		Engineering Water Jet Supplier Quality					
Root Cause		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
Operator		Completed By		QC / QA Coordinator		Lead hand / Supervisor			
Manufacturing Process									
Equip/Tooling									
Handling/Preservation									
Material									
Product Improvement									
Process Improvement									
Human Factors									